

Work Order ID 65884

Wednesday, January 26, 2011 1:54:31 PM



Page 1

Item ID: D4275-1

Accept



Setup Start



Revision ID:

Item Name: Fwd Beam

Stop



Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: 11-01-26 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4275

A

100

0.00



BAND SAW

0.00

Bandsaw

Memo

Jeaspa Bandsaw

Cut Blank to 39.750"

Batch: 116808 (x3)

107221 (x1)

SL 11/04/11

4

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Machine per folio FB006

DWG REV: A

FOLIO REV: AA

B.A 11/04/12

4

φ

2- deburr rough edges

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

- QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

B.A 11/04/12

4

0

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

CML 11/04/13

4

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

H BR 11-4-13.

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

145

Powdercoat
Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M116 964. START: 10:30
Memo
MASK AS PER DWG
OVERT. 3:00
FINISH: 11:00.

4. BL 11-473.

150

QC
Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

4 d 11/04/13

180

Packaging
Packaging

Identify as per dwg & Stock Location: 51200

0.00

Memo

0.00

EP 11/04/14 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/15

11-04-14

4

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 26, 2011 1:54:37 PM

Page 1

Work Order ID: 65884

Parent Item: D4275-1

Parent Item Name: Fwd Beam



Start Date: 1/26/2011

Required Date: 2/4/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP rev:B
10.12.02 AS PER DWG REV.A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B1.000X04.00
0

Purchased

No

100

f

53.2995

3.3125

13.94737



6061-T6 Bar 1.00 x 4.00

SL 11/04/11

Location

Loc Qty

Loc Code

MAT03

53.2995

107221

45.2937

114352

8.0058

116808X3

3.45

10.5

3.45

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 65884
Description: FWD BEAM	Part Number: D4275-1
Inspection Dwg: D4275 Rev: A	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/- .030	0.750	✓		Vern	GA-01
26.700	+/- .010	26.700	✓		TAPE	GA-12
φ0.381	+0.000 / - .001	φ0.3810	✓		Mic	GA-03
8.280	+/- .010	8.280	✓		H-6	31006
1.44	+/- .030	1.440	✓		Vern	GA-01
0.95	+/- .030	0.950	✓		"	"
3.50	+/- .030	3.501	✓		"	"
13.28	+/- .030	13.280	✓		Tape	GA-12
13.50	+/- .030	13.500	✓		"	"
9.25	+/- .030	9.250	✓		Vern	CNC-02
5.00	+/- .030	5.000	✓		Vern	GA-01
0.75	+/- .030	0.750	✓		"	"
2.75	+/- .030	2.750	✓		"	"
3.00	+/- .030	3.001	✓		"	"
1.250	+/- .010	1.251	✓		"	"
4.50	+/- .030	4.500	✓		"	"
0.734	+/- .010	0.737	✓		"	"
0.108	+/- .010	0.103	✓		H-6	31006
39.48	+/- .030	39.480	✓		Tape	GA-12
0.95	+/- .030	0.951	✓		Vern	GA-01
0.60	+/- .030	0.600	✓		"	"
1.750	+/- .010	1.750	✓		"	"
2.700	+/- .030	2.697	✓		"	"

Measured by: BA	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: 11/04/12	Date: 11/04/13	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 65884
Description: FWD BEAM		Part Number: D4275-1
Inspection Dwg: D4275 Rev: A		Page 2 of 2

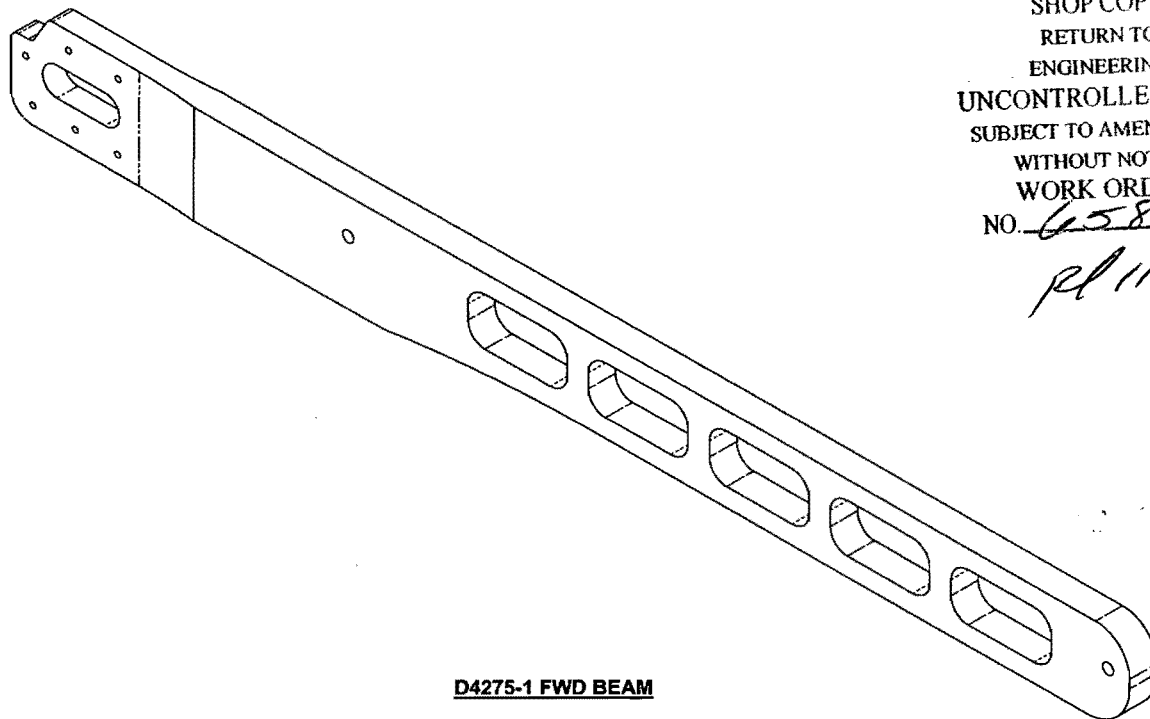
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.10	+/- .030	1.101	✓		Vern	GA-01
1.25	+/- .030	1.253	✓		"	"
0.900	+/- .010	0.900	✓		H-6	31006
0.75	+/- .030	0.751	✓		Vern	GA-01
0.250	+/- .010	0.250	✓		H-6	31006
3.000	+/- .010	3.000	✓		Vern	GA-01
1.500	+/- .010	1.500	✓		"	"
φ0.191	+0.005 / -0.001	φ0.193	✓		"	"
2.300	+/- .010	2.300	✓		"	"
3.50	+/- .030	3.500	✓		Vern	GA-01
R0.60	+/- .030	R0.600	✓		R-6	ref.
1.70	+/- .030	1.700	✓		Vern	GA-01
0.65	+/- .030	0.653	✓		"	"

Measured by: B.A.	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: 11/04/12	Date: 11/04/13	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4275-1 FWD BEAM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65884
PL 11-01-26

RELEASED
2010-11-30

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.29 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT.

A NEW ISSUE		SC	10.11.25
REV.	DESCRIPTION		BY DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4275	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 1 OF 2	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD BEAM	NTS
DATE	10.11.25	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR LOANED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

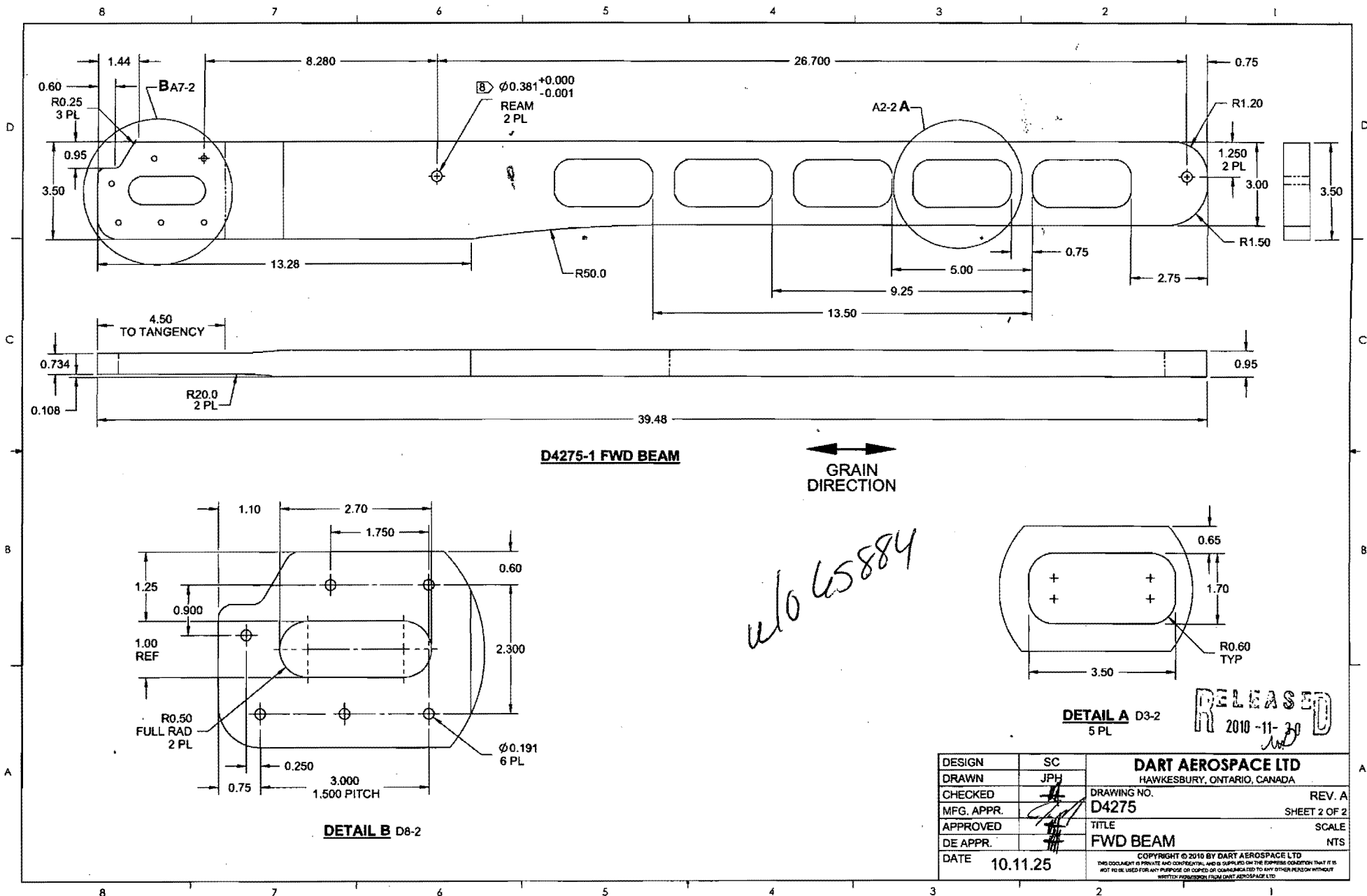
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